Work Order September-27-13 1	·		*107!	553*							Page 1
Revision ID:	3016-15		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	171.	S1* S2*
Start Date: 9/2 Required Date: 9/2 Reference:	27/13 Start Qty: 27/13 Req'd Qty:			Cust Item I Customer:	D:						
Approvals: P	rocess Plan: MC5	Date: /3-09-3		D	ate:	_	1		Start	*N	R1*
	C:				ate:				Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	i							.,		
D3016	Rev A	:									
100 *100* Waterjet FLOW CNC Waterjet -1(30.049)	1-0	R JET emo Cut as per Dwg D3016 Dwg Roburr if necessary	0.00 0.00 ev: A Prog Rev: A				<u>4</u>		:		JMB 12-2
110		arts off machine FAI/FAIB	0.00								
110 QC Quality Control	Мо	emo	0.00				4				Jm B-12.
¹²⁰ *1 2∩*	QC8- Inspect p	parts - second check	DAS 27 9-89 12)9			4				
QC	Mo	emo	0.00	1							

Quality Control

										DQA:	Date:		
NCR: Y	'es	/ No				WORK ORDER NON-C	CONFOR	MANCE / UP		QA Closed:	Date:		
Work Orde	Work Order:					DISPOSITION		AGAINST DEI	NST DEPARTMENT/PROCESS				
Part N	-					Rework Scrap Use-as-is		Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	10	 	<u>.</u>		<u>.</u>	Work Order Update		Large Fab	Composite	Necy Stor	Supplier		
Root					Descri	ption of work order update	Initial	Act	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data						· · · · · · · · · · · · · · · · · · ·							
Equip/Tooling													
Operator													
Material											: 1		
Setup													
Other													
Process													
Supplier											,		
Training													
			3				1	ī					

FAULT CATEGORY

General

Bend Grain Ovalized Pressure/Forced Bending Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection incomplete Part Incorrect Weld Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Cut Too Short Power Loss/Surge Other Inspection Strip in Tube Misread Offset Ripples in Bend Drill Holes Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Folio Wave/Twist in Tube **Outside Dimensions**

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Unapproved

Landing Gear

September-27-1.	3 12:47:58 P	<u>'M</u>			. 1. 1. 1						
Item ID: Revision ID:	D3016-15			Accept	*N900	040	100)* s	Setup Sta	1.7	IS1*
Item Name:	Gusset								Sto	^p *N	S2 *
Start Date:	9/27/13	Start Qty: 4.00	*4*		Cust Item II) :					
Required Date:	9/27/13	Req'd Qty: 4.00	*4*		Customer:						
Reference:									S40	4	
Approvals:	Process Pla	an:	Date:	Tooling:	Da	te:		ŀ	Run Sta	"I \	IR1*
					Da	te:			Sto	^{op} *\	IR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130				0.00					544		
130 Packaging		Packaging Memo		0.00				4×	28 9-89	13-12-	9
Packaging		Identify and LARGE FA Location:)	B****	a oil #2), then Stock ****	*STOCK IN				- 30		
140		QC21- Final Inspection	Work Order Release	0.00					13/1	2/10	del
140 QC Quality Control		Memo		0.00					1/110	~100	7()—

Pl13-12-10

				DQA:_	Dat	e:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE				

											QA Closed:	D	ate:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	1	
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Composi			Pro Rec/Stor	-	Engineering Quality Other	
Root		-			Descri	ption of work order update	Ī	nitial	Act	tion	Sign &			
Cause	-	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verificati	on	QC Inspector
Doc/Data														
Equip/Tooling														
Operator													.	
Material													'	
Setup													.	
Other													ı	
Process														
Supplier													!	
Training	Ш						1						.	
Unapproved													. 1	
						F	AUL	T CATE	GORY				i .	
Landi	ng (Sear				General		1			•			
		Bending				Bend		Grain			Ovalized		\vdash	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa			Over/Under		. —	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	<u></u>	1 '	ion Incomplete	<u> </u>	Part Incorred		-	Weld
		Crushed/	Crimped		<u> </u>	Burrs	—	1	tions Incomplete/	Unclear	Part Lost/Mi	ssing	. Ш	Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	_	Mainte		<u> </u> _	Part Moved	i		
	\vdash	Heat Trea			<u>_</u>	Countersink	<u></u>	Mislabe		L	Positioned V	_		
		Inspection	-	Tube	<u> </u>	Cut Too Short	_	Misread	d		Power Loss/	Surge	Ш	Other
	<u> </u>	Ripples in			<u> </u>	Drill Holes		Offset						
		Torque W			n	Drawing	\vdash	4	Calibration			.!		
				Finish	<u>_</u>	1	Sequence							
Wave/Twist in Tube				Folio		Outside	Dimensions							

Picklist Print

September-27-13 12:47:58 PM

Work Order ID:

107553

Parent Item:

D3016-15

Parent Item Name:

Gusset .

Start Date: 9/27/13

Required Date: 9/27/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP B03.05.09ReformatKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 4130 Sheet .049		Purchased	No			100	sf	119.5903	0.0486	0.2046316 O. ƏS	1:		J~B-73
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT020		119.590263							
				116	12	4.2			-				
				123	049	17.340263							
				124	283	98.05	•		75,	(383)			

21 / 22

DQA: Date:	4
------------	---

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCR.	es / 110						J1111	VIAITEL / OI		QA Closed:	Da	ite:	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	o				Rework Scrap] ₋ ,	1	Skid-tube Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor.		Engineering Quality Other
NCR N	o				Use-as-is Work Order Update	<u> </u>		noforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier	\blacksquare	Other
Root				Descri	ption of work order update	Initia	al	Ac	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Doc/Data													
Equip/Tooling						ļ							
Operator													
Material						1				<u> </u>			
Setup												Į	
Other													
Process												1	
Supplier													
Training						1							
Unapproved													
	,					AULT C	ATE	GORY					
Landin	ng Gear				General	_				7			
ļ	Bending			<u> </u>	Bend	Gra				Ovalized		-	Pressure/Forced
	Centre No	ot Conce	ntric to C	D/S	BOM/Route		rdwa			Over/Under		\rightarrow	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	-	•	ion Incomplete		Part Incorre		-	Weld
	Crushed/	Crimped			Burrs	_		tions Incomplete/	'Unclear	Part Lost/M	•		Wrong Stock Pulled
	Cuffs				Contamination	Má	ainte	enance		Part Moved			
	Heat Trea	ət		L	Countersink	Mis	slabe	eled		Positioned V	_		
	Inspectio	n Strip in	Tube		Cut Too Short		sread	d	L	Power Loss/	'Surge		Other
	Ripples in	n Bend			Drill Holes	Off	fset						
	Torque W	Vaves in E	Extrusion	· [Drawing	Ou	t of (Calibration					
	Turning S	equence	!		Finish	∐Ou	t of S	Sequence				,	
	Wave/Tw	ist in Tul	be	[Folio	Ou	itside	Dimensions					

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DART AEROSPACE LTD	Work Order:	10 7513
Description: Gusset	Part Number:	D3016-15
Inspection Dwg: D3016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.50"			V	Jkmon
2.50	+/-0.030	2.50"	-		V	
0.15	+/-0.030	6.15	_		V	
0.15	+/-0.030	10.15"	_		V	
0.450	+/-0.010	6.450"	_		ν	
0.049	+/-0.010	0.049"	-		V	
4			,			
	_					***************************************
	! :	,				
			DAS			
easured by:	Jm	Audited by:	27 9-89		Preliminary	Approval

Measured by:	Audited by:	9-89	Preliminary Approval:	
Date: 13-12-9	Date:	13-12-09	Date:	

Rev	Date	Change	Revised by	Approved
Α	11.04.28	New Issue	KJ K	1
		-,	1//	· · · · · · · · · · · · · · · · · · ·

		1									DQA:	Date	
NCR: Y	'es /	/ No				WORK ORDER NON-C	ON	FORN	/ANCE / UPI	DATE	QA Closed:	 Date	:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	_ lo	:				Rework Scrap Use-as-is Work Order Update	Machining Small Fab s-is Thermoforming Finishing			Small Fab Finishing	→	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T				Descri	ption of work order update	Ir	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			·										
		· ·					AUL'	CATE	GORY				
Landir		Bending Centre No Cracks Crushed/ Cuffs Heat Trea nspection	Crimped it n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Instruct Mainte Mislabe Misreac	ion Incomplete ions Incomplete/l enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	F	Ripples.in	Bend		l	Drill Holes	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio





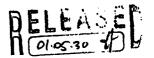
DESIG	n UP	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, C	
CHEC	KED .	APPROVED	DRAWING NO.	REV. A
1	4	 	D3016	SHEET 1 OF 3
DATE			TITLE	SCALE
01.0	05.18		SEAT FRAME ASSEMBLY	NTS
Α		01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
Х	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
			,
. 2	D3020-1	FITTING	N/A
 	100020-1	1,,,,,,,	

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEO ATTACHED



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NCR:	Yes	/	No

		l l								DQA:	Date	•		
NCR: Y	es	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UPDATE	OA Classel	Data			
										QA Closed:	Date	<u> </u>		
Nork Orde	r:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
	-					Rework]		Skid-tube Crosstube		Water Jet	Engineering		
Part N	lo.					Scrap		l	Machining Small Fab	Pro	d. Eng. Coor.	Quality		
	_	i				Use-as-is		Thern	noforming Finishing	Rec/Sto	re/Packaging	Other		
NCR N	lo.	!				Work Order Update	┚┃		Large Fab Composite		Supplier]		
Root	\neg	· · · · ·			Descr	iption of work order update		nitial	Action	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector		
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ther							Ì			1				
rocess	_	1												
upplier	_	1									1			
raining														
inapproved							\perp			" .				
							FAUL	T CATE	GORY					
Landi	_				_	General		7	!		_	-		
		Bending				Bend	\perp	Grain		Ovalized	-	Pressure/Forced		
i	_	Centre No	ot Conce	ntric to	o/s	BOM/Route	\perp	Hardwa		Over/Under	ļ	Temperature/Cure		
		Cracks			<u> </u>	Broken/Damaged	<u> </u>	4 `	ion Incomplete	Part Incorre	├	Weld		
	\vdash	Crushed/	Crimped		<u> </u>	Burrs	<u> </u>	4	tions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs					Contamination	\perp	Mainte		Part Moved				
	Heat Treat					Countersink	_	Mislabe		Positioned V		_		
	$\overline{}$	Inspecțio	-	Tube		Cut Too Short		Misrea	d	Power Loss/	Surge	Other		
		Ripples in			Ļ	Drill Holes	_	Offset				· · · · · · · · · · · · · · · · · · ·		
	Ш	Torque W			n _	Drawing	_	-{	Calibration					
		Turning S	equence			Finish		Out of	Sequence					

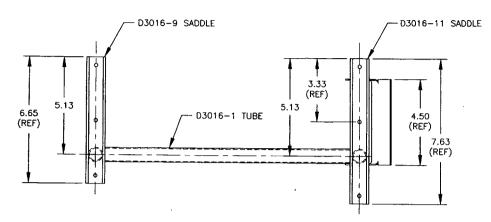
Outside Dimensions

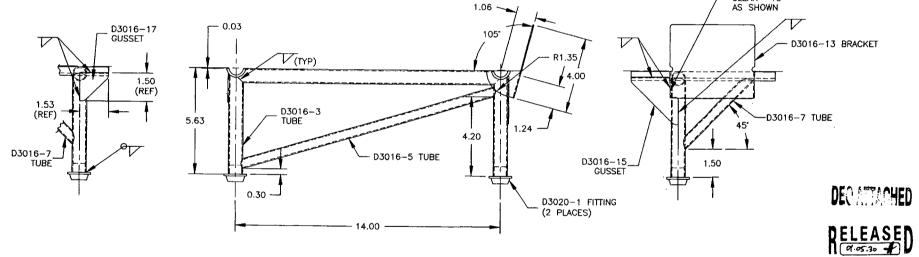
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Wave/Twist in Tube

Folio

D3016-041 SEAT FRAME ASSEMBLY





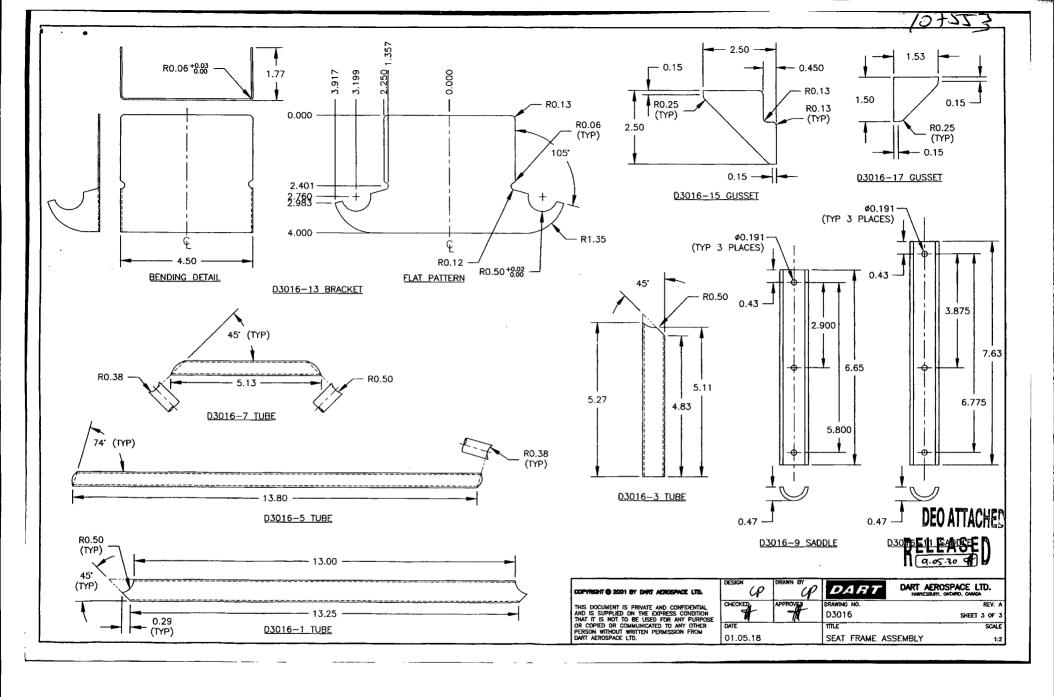
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	DESIGN UP	DRAWN BY	DART	DART AEROSPACE LTD. HARRESBURY, ONTARO, CANADA
	CHECKED	APPROVED.	DRAWING NO. D3016	REV. SHEET 2 OF
•	DATE	<u> </u>	TITLE	SCAL
	01.05.18		SEAT FRAME AS	SEMBLY 1:

											DQA:	Dat	te:		
NCR: Y	es	/ No				WORK ORDER NON-	CON	4FORN	MANCE / UPDATE		•				
··							QA Closed: Date:								
Vork Orde	ŗ.					DISPOSITION			AGAINST (DEPARTMENT/PROCESS					
von orac	٠					Rework	1 1		Skid-tube Crosstube	\neg	Water Jet			Engineering	
Part N	0					Scrap	1		Machining Small Fab	\dashv	Pro	d. Eng. Coor.	Н	Quality	
1 01 11	٠				<u> </u>	Use-as-is	1	į.	noforming Finishing	_		e/Packaging	Н	Other	
NCR N	o.					Work Order Update	1		Large Fab Composite	\dashv	1100,0101	Supplier	Н		
	-						١							<u></u>	
Root					Descri	ption of work order update	1	nitial	Action		Sign &	i			
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		Cracks			_	Broken/Damaged		4	ion Incomplete		art Incorred		<u> </u>	Weld	
	_	Crushed/0	Crimped		_	Burrs	_	1	tions Incomplete/Unclear	_	art Lost/Mi	ssing	<u> </u>	Wrong Stock Pulled	
	Cuffs					Contamination	_	Mainte	<u>}</u>	——	art Moved	!	ı		
	Heat Treat					Countersink	_	Mislabe	ŀ		ositioned V			 	
i	Inspection Strip in Tube					Cut Too Short		Misread	d [P	ower Loss/	Surge	<u></u>	Other	
		Ripples in			<u> </u>	Drill Holes	\vdash	Offset		_			:		
į		Torque W			`	Drawing	\vdash	-1	Calibration						
		Turning Se			<u> </u>	Finish	Out of Sequence						:		
		Wave/Twi	ist in Tub	oe e	į	Folio		Outside	Dimensions				!		

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												DQA:	Date	e:		
NCR: Y	es	/ No				WORK ORD	DER NON-CO	ON	FORN	MANCE / UPI	DATE	QA Closed:	Date	e:		
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Part N	o					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			-	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
Root			_			iption of work or	'		itial	Act		Sign &				
Cause	4	Date Step Qty or Non-conformance						Chie	ef Eng	Descr	iption	Date	Verification	QC Inspector		
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	\rightarrow	centre No	t Concor	atric to 1	\s\ \-	BOM/Route	-		ardwa	ro	F	Over/Under	tolerance	Temperature/Cure		
	\neg	Cracks	it concer	itile to), ₃ -	Broken/Damag	ed	_		on incomplete	-	Part Incorre	ı F	Weld		
		Crushed/0	rimped		-	Burrs	-Cu	-	•	ions Incomplete/L	Inclear	Part Lost/Mi	⊢	Wrong Stock Pulled		
			ampeu		<u> </u>	Contamination		_	Mainte	•	-	Part Moved	33111g	Wrong Stock / uncu		
	-	⊣ ⊢				Countersink		-	Mislabe		-	Positioned V	Vrong			
	F-4 F-1					Cut Too Short	ŀ	—	Misread		<u> </u>	Power Loss/		Other		
	Ripples in Bend Drill Holes						1		Offset	•	Ŀ			37.01		
		Torque W		xtrusio	, F	Drawing	ŀ			Calibration						
		Turning Se			¨ -	Finish		_		equence			1			
	_	Wave/Twi			F	Folio		—		Dimensions						

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DRAWING NO.	TITLE		REV. A	DART AE	ROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D3016	SEAT F	RAME ASSEMBL	Y	ENGINE	ERING ORDER	D3016-A-1	SHEET 1 OF 1	NTS
DRAWN		CHECKED	(1)	MFG. APPR.	R	APPROVED A	DE APPR.	
DATE 10	.01.29	DATE 10	2.01.75	DATE	10,01.29	DATE 10.01.29	DATE 10.01-29	-

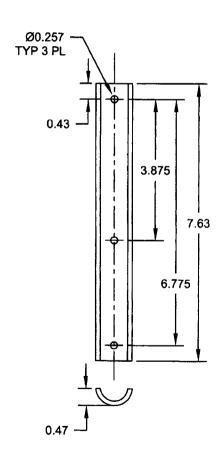
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

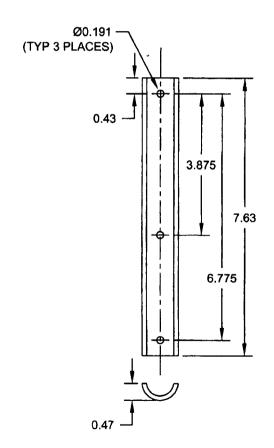
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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NCR: Ye	es / No				WORK ORDER NON-C	CONF	FORN	MANCE / UPI	DATE	QA Closed:	Da	te:	
Work Ordei	·				DISPOSITION	1	AGAINST DEPARTMENT/PROCESS						
Part No					Scrap Use-as-is Work Order Update	Scrap Machining Small Use-as-is Thermoforming Finis			Crosstube Small Fab Finishing Composite	Fab Prod. Eng. Coor. Quality hing Rec/Store/Packaging Other			
NCK IV	·				Work Order Opdate	<u> </u>					Supplier		
Root					ption of work order update	l .	itial		tion	Sign &	r.		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verificatio	n QC Inspe	ector
Doc/Data													
quip/Tooling											i		
Operator	_			ن		1					!		
√aterial	_										1		
etup	_												
Other											1		
Process													
Supplier	_					İ							
raining	_	ļ						·			,		
Jnapproved		l				<u> </u>							
						AULT	CATE	GORY			i 		
Landin	-				General				_	٦		<u> </u>	
1	Bending			_	Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/For	
-	Centre No	ot Concei	ntric to (o/s _	BOM/Route	\mathbf{H}	lardwa		<u> </u>	Over/Under		Temperature	e/Cure
	Cracks			<u> </u>	Broken/Damaged		-	on Incomplete		Part Incorre		Weld	
-	Crushed/	Crimped		<u> </u>	Burrs	\vdash		ions incomplete/	Unclear	Part Lost/M	ssing	Wrong Stock	Pulled
-	Cuffs				Contamination	\vdash		enance	-	Part Moved			
	Heat Trea			<u> </u>	Countersink	⊢	∕islabe		<u> </u>	Positioned V	_	·—	
Ļ	Inspection Strip in Tube				Cut Too Short	\vdash	<i>M</i> isread	1	L	Power Loss/	Surge	Other	
1	<u> </u>				Drill Holes	\vdash	Offset						
Ĺ	Torque Waves in Extrusion Drawing				Drawing	Out of Calibration							
L	Turning S			Finish	Out of Sequence								
ļ	Wave/Tw	ist in Tul	oe .	-	Folio		Outside Dimensions			_			

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G